

Work Order ID 54541

December 11, 2009 9:23:59 AM



Page 1

Item ID: D2580-1

Accept



Setup Start



Revision ID:

Item Name: 205 Skidtube bent detail

Stop



Start Date: 12/14/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 12/16/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MFDate: 09-12-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2580	Rev D

100



HandFinish

Memo

0.00

D - AWN 9-12-10

Hand Finishing

1- Inspect mat'l D2500-1-190 for damage.
2- Chemical Conversion Coat as per QSI 005 4.1

101



QC3- Inspect Part Finish

0.00

DP 9-12-10

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110



Skidtubes

Memo

0.00

2

- Aum 9-12-10

Skidtubes

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

A/R Sikaflex-291 batch: 3010/10/30

Sikaflex expire date: _____

m 112395

Start time: _____ bond for 12hrs

2:15

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00


 9-12-11

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Picklist Print

December 11, 2009 9:23:59 AM

Page 1

Work Order ID: 54541



Parent Item: D2580-1



Parent Item Name: 205 Skidtube bent detail

Start Date: 12/14/2009

Required Date: 12/16/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2500-1-190		Manufactured		No			Each	108.0000	2.0000			

Ext'n - 'I' Beam Tube 4"

Warehouse

Location

Main Warehouse

LG	105
50166	4
52319	101

AWM

1150166-9-12-10

Main Warehouse

ST	3
46468	3

110	Each	3.0000	2.0000
-----	------	--------	--------

D2596



Manufactured

No

Warehouse

Location

Main Warehouse

LG	3
53263	1
53891	2

AWM 9-12-10

Web, 205 Skidtube

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DART

DESIGN <i>#</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *#*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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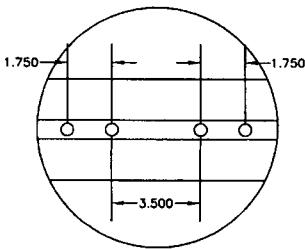
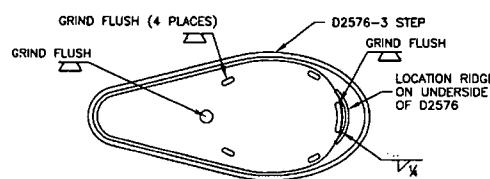
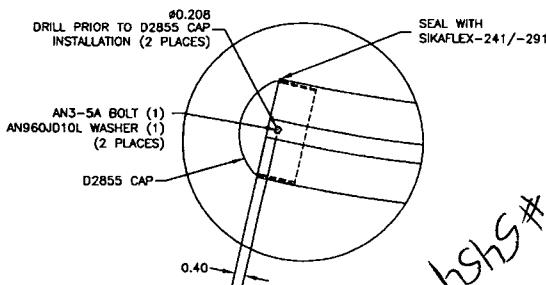
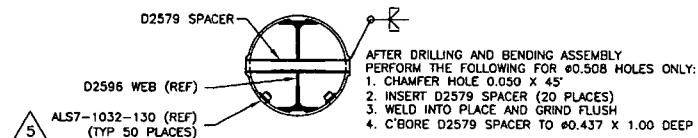
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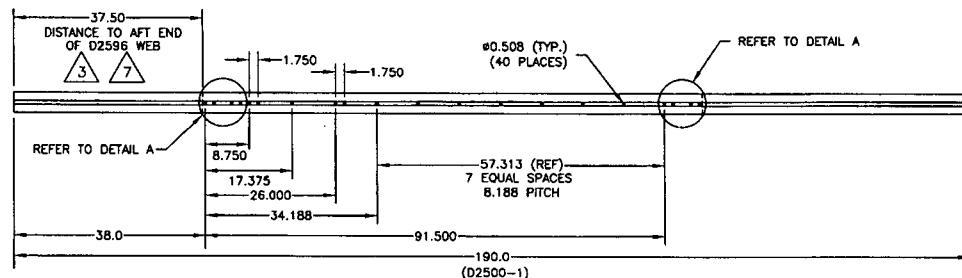
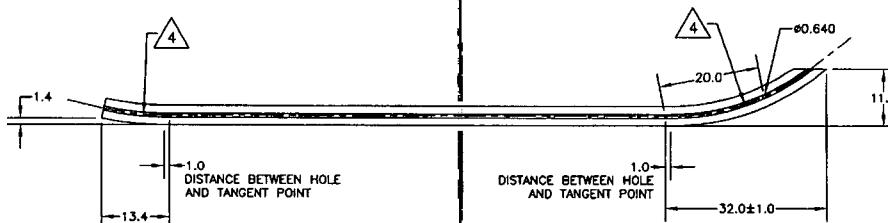
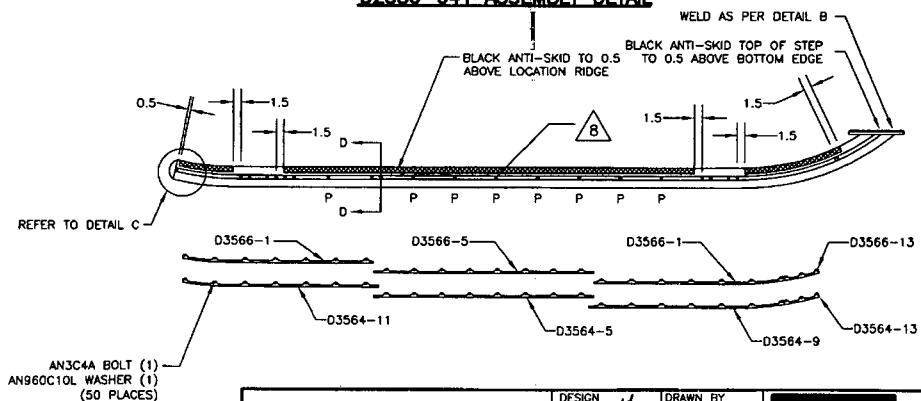
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DETAIL A
SCALE 5:24**RELEASED**
07-06-28**DETAIL B**
SCALE 5:24**DETAIL C**
SCALE 5:24**SECTION D-D**
SCALE 5:24**D2580-041 NOTES**

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

D2580-1 DRILLING DETAIL**D2580-1 BENDING AND CUTTING DETAIL****D2580-041 ASSEMBLY DETAIL**AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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DESIGN	DRAWN BY	DART		DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED	APPROVED			REV. D
				DRAWING NO. D2580
DATE				SHEET 2 OF 3 TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24

07.02.27

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